

Work Order ID **56673**

March 4, 2010 11:26:46 AM

Page 1

Item ID: D412-742-043

Accept



Setup Start



Revision ID:

Item Name: Replacement Float Skidtube

Stop



Start Date: 3/04/10 Start Qty: 1.00



Cust Item ID:

Required Date: 3/12/10 Req'd Qty: 1.00



Customer:

Reference:

Approvals:

Process Plan: W

Date:

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Draw
Number

Draw
Rev.

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

Draw Nbr

Revision Nbr

D3391

Rev H

100

0.00



DOCUMENT CONTROL

DC

Memo

0.00

Document Control

If D412-742-043 is a W/O on it's own,
Photocopy bluefile and create labels per PPP D412-742-043 CHG004

N/A *[Signature]*

Work Order ID 56673

March 4, 2010 11:26:51 AM

Page 2

Item ID: D412-742-043

Accept

Revision ID:

Item Name: Replacement Float Skidtube

Start Date: 3/04/10 Start Qty: 1.00

Required Date: 3/12/10 Req'd Qty: 1.00

Cust Item ID:

Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Run Start
Stop

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	----------------	--------------	--------------	---------------	---------------	------------------	----------------

110

0.00



HandFinish

HandFinishing

Memo

0.00

Hand Finishing

1-Install tubes together and seal them all the way around using Sikaflex 241/291. Ensure tube ends line-up with saddle holes for proper alignment. using 7/16" "T" Pins.

A/R ☐ Sikaflex-241/-291 M112429
Expiry date: 10/08

2-Install wearplates as per Dwg D3391. Ensure that plastic washers are against wearplate, then topped with the SS washer. Seal all bolts with sikaflex except ones with inserts on inside of tube, hand tighten only bolts with no sikaflex.

A/R ☐ Sikaflex-241/-291 M112429
Expiry date: 10/08

3-Remove "T" pins once sikaflex is dry.

4-Coat all exposed hardware with LPS Procyon. Remove any excess off with MEK degreaser.

A/R ☐ LPS Procyon 104251

bf 10-4-21 ①

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Item ID: D412-742-043

Accept



Setup Start



Revision ID:

Item Name: Replacement Float Skidtube

Stop



Start Date: 3/04/10 Start Qty: 1.00



Cust Item ID:

Required Date: 3/12/10 Req'd Qty: 1.00



Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Run Start



Stop



Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Draw
Number

Draw
Rev.

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

120



QC

Quality Control

QC5- Inspect part completeness to step on W/O

0.00

Memo

0.00

510427



130



Packaging

Packaging

Packaging

Memo

Identify and pack for shipping as per PPP D412-742-043

Location: _____

PPP Rev: _____

0.00

0.00

PPP

56676

10-4-27 SP

140



QC

Quality Control

QC21- Final Inspection - Work Order Release

0.00

Memo

0.00

10/04/27

mf 10-4-27

Picklist Print

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Page 1

Work Order ID: 56673

Parent Item: D412-742-043

Parent Item Name: Replacement Float Skidtube

Comments: IPP Rev A 05.10.13 New Issue
IPP Rev B 06.02.13 ECN 773 dwg @ rev.D
IPP Rev: C 07-05-28 As per Rev F
IPP Rev: D 07-12-04 ECN 1072

KJ/JLM
EC
JLM
DD verified by: JLM

Start Date: 3/04/10

Start Qty: 1.00

Required Date: 3/12/10

Required Qty: 1.00

AN3C4A Purchased No 110 Each 1,333.000 24.0000



BOLT

Warehouse Loc Qty Loc Code

Location

Main Warehouse

ST	114330	1333
112314		13
112720		12
112724		3
112829		1
112991		2
113121		64
113226		344
113644		294
113749		100
114103		500

24. BR 10-4-21.

AN3C6A Purchased No 110 Each 730.0000 12.0000



BOLT

Warehouse Loc Qty Loc Code

Location

Main Warehouse

ST		730
111982		730

12 BR 10-4-21.

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

Page 2

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Work Order ID: 56673



Parent Item: D412-742-043



Parent Item Name: Replacement Float Skidtube

Start Date: 3/04/10

Required Date: 3/12/10

Comments: IPP Rev A 05.10.13 New Issue
IPP Rev B 06.02.13 ECN 773 dwg @ rev.D
IPP Rev: C 07-05-28 As per Rev F
IPP Rev: D 07-12-04 ECN 1072

KJ/JLM
EC
JLM
DD verified by: JLM

Start Qty: 1.00

Required Qty: 1.00

AN3C7A Purchased No 110 Each 493.0000 8.0000



BOLT

Warehouse Loc Qty Loc Code

Location

Main Warehouse

ST 493

105906 21

107376 252

113149 220

AN960C10L Purchased No 110 Each 388.0000 44.0000



washer

Warehouse Loc Qty Loc Code

Location

OFFSHORE

FG 100

103585 100

Main Warehouse

ST 288

112116 128

112612 160

D3391-021 Manufactured No 110 Each 0.0000 1.0000



Fwd Tube Assembly

NAS1149C0332R

*

used on
D3391-023
#53472 53475

8. BR 10-4-21.

44. BR 10-4-21.

1 BR 10-3-4.

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Shop Packet Print

Page 2

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

Page 3

March 4, 2010 11:23:52 AM

Work Order ID: 56673

Parent Item: D412-742-043

Parent Item Name: Replacement Float Skidtube

Comments: IPP Rev A 05.10.13 New Issue
IPP Rev B 06.02.13 ECN 773 dwg @ rev.D
IPP Rev: C 07-05-28 As per Rev F
IPP Rev: D 07-12-04 ECN 1072

KJ/JLM
EC
JLM
DD verified by: JLM

Start Date: 3/04/10

Required Date: 3/12/10

Start Qty: 1.00

Required Qty: 1.00

D3391-023

Manufactured No

110

Each

2.0000

1.0000



Mid Tube Assembly

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

ST

53942

2

40522

1

53938

1

1 BR 10-3-4.

D3391-025

Manufactured No

110

Each

3.0000

1.0000



Aft Tube Assembly

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

ST

54701

3

39129

1

48122

1

54703

1

1 BR 10-4-21.

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

March 4, 2010 11:23:53 AM

Work Order ID: 56673



Parent Item: D412-742-043



Parent Item Name: Replacement Float Skidtube

Start Date: 3/04/10

Required Date: 3/12/10

Comments: IPP Rev A ☐ 05.10.13 ☐ New Issue ☐
 IPP Rev B ☐ 06.02.13 ☐ ECN 773 dwg @ rev.D
 IPP Rev: C 07-05-28 As per Rev F
 IPP Rev: D 07-12-04 ECN 1072

KJ/JLM ☐
 EC
 JLM
 DD verified by: JLM

Start Qty: 1.00

Required Qty: 1.00

D3564-1 Manufactured No 110 Each 19.0000 1.0000



Wearshoe

<u>Warehouse</u>	<u>Loc Qty</u>	<u>Loc Code</u>
<u>Location</u>		
OFFSHORE		
FG	2	
33798	2	
Main Warehouse		
ST	17	
47531	1	
50270	1	
51676 ✓	15	

1 BR 10-4-21

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

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Work Order ID: 56673



Parent Item: D412-742-043



Parent Item Name: Replacement Float Skidtube

Start Date: 3/04/10

Required Date: 3/12/10

Comments: IPP Rev A 05.10.13 New Issue
 IPP Rev B 06.02.13 ECN 773 dwg @ rev.D
 IPP Rev: C 07-05-28 As per Rev F
 IPP Rev: D 07-12-04 ECN 1072

KJ/JLM
 EC
 JLM
 DD verified by: JLM

Start Qty: 1.00

Required Qty: 1.00

D3564-3

Manufactured No

110

Each

20.0000

1.0000



Wearshoe

Warehouse

Loc Qty

Loc Code

Location

OFFSHORE

FG

2

33764

2

Main Warehouse

FP

6

50113 ✓

6

Main Warehouse

FP19

11

55489

11

Main Warehouse

ST

1

46445

1

1 BL 10-4-21.

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W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

March 4, 2010 11:23:54 AM

Work Order ID: 56673



Parent Item: D412-742-043



Parent Item Name: Replacement Float Skidtube

Start Date: 3/04/10

Required Date: 3/12/10

Comments: IPP Rev A 05.10.13 New Issue
 IPP Rev B 06.02.13 ECN 773 dwg @ rev.D
 IPP Rev: C 07-05-28 As per Rev F
 IPP Rev: D 07-12-04 ECN 1072

KJ/JLM
 EC
 JLM
 DD verified by: JLM

Start Qty: 1.00

Required Qty: 1.00

D3564-5 Manufactured No 110 Each 37.0000 1.0000



Wearshoe

<u>Warehouse</u>	<u>Loc Qty</u>	<u>Loc Code</u>
<u>Location</u>		
OFFSHORE		
FG	2	
34806	2	
Main Warehouse		
FP19	33	
51925	1	
54772	7	
55024	12	
55333 ✓	13	
Main Warehouse		
ST	2	
45824	1	
47433	1	

BL 10-4-01.

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

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Work Order ID: 56673



Parent Item: D412-742-043



Parent Item Name: Replacement Float Skidtube

Start Date: 3/04/10

Required Date: 3/12/10

Comments: IPP Rev A 05.10.13 New Issue
IPP Rev B 06.02.13 ECN 773 dwg @ rev.D
IPP Rev: C 07-05-28 As per Rev F
IPP Rev: D 07-12-04 ECN 1072

KJ/JLM
EC
JLM
DD verified by: JLM

Start Qty: 1.00

Required Qty: 1.00

D3566-1 Manufactured No 110 Each 25.0000 2.0000



Gasket

<u>Warehouse</u>	<u>Loc Qty</u>	<u>Loc Code</u>
<u>Location</u>		
Main Warehouse		
FP 57257	20	
52512	3	
54480	1	
55011	1	
55320	15	
Main Warehouse		
ST	5	
46349	1	
51218	1	
51259	3	

2. BR 10-4-21

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

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Work Order ID: 56673



Parent Item: D412-742-043



Parent Item Name: Replacement Float Skidtube

Start Date: 3/04/10

Required Date: 3/12/10

Comments: IPP Rev A 05.10.13 New Issue
IPP Rev B 06.02.13 ECN 773 dwg @ rev.D
IPP Rev: C 07-05-28 As per Rev F
IPP Rev: D 07-12-04 ECN 1072

KJ/JLM
EC
JLM
DD verified by: JLM

Start Qty: 1.00

Required Qty: 1.00

D3566-5

Manufactured No

110

Each

27.0000

1.0000



Gasket



Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

FP19

56829

23

55026

11

55335

12

Main Warehouse

ST

4

36113

1

46186

1

47318

1

51260

1

1 BR 10-4-21

March 4, 2010 11:23:55 AM

Shop Packet Print

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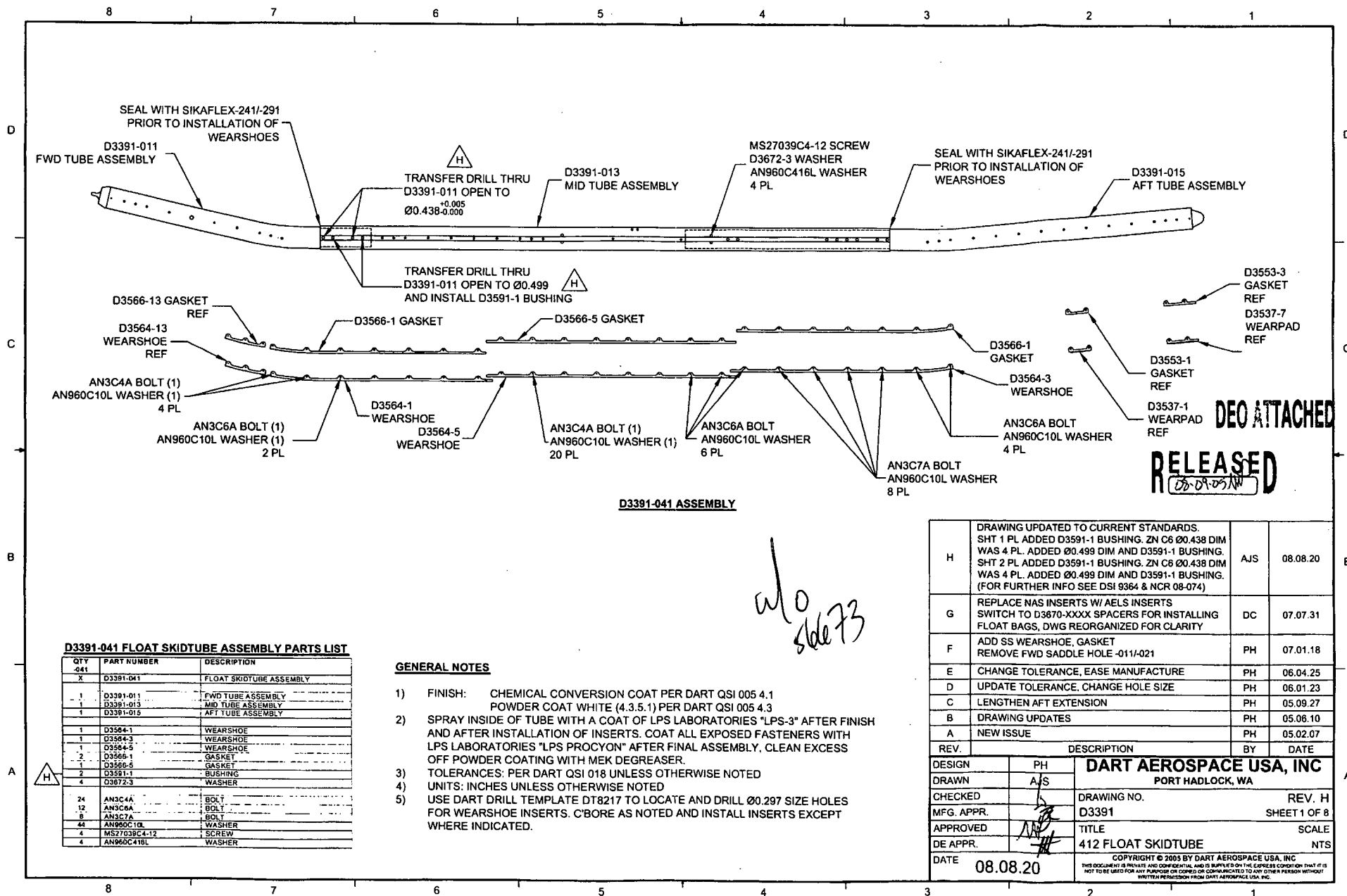
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DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

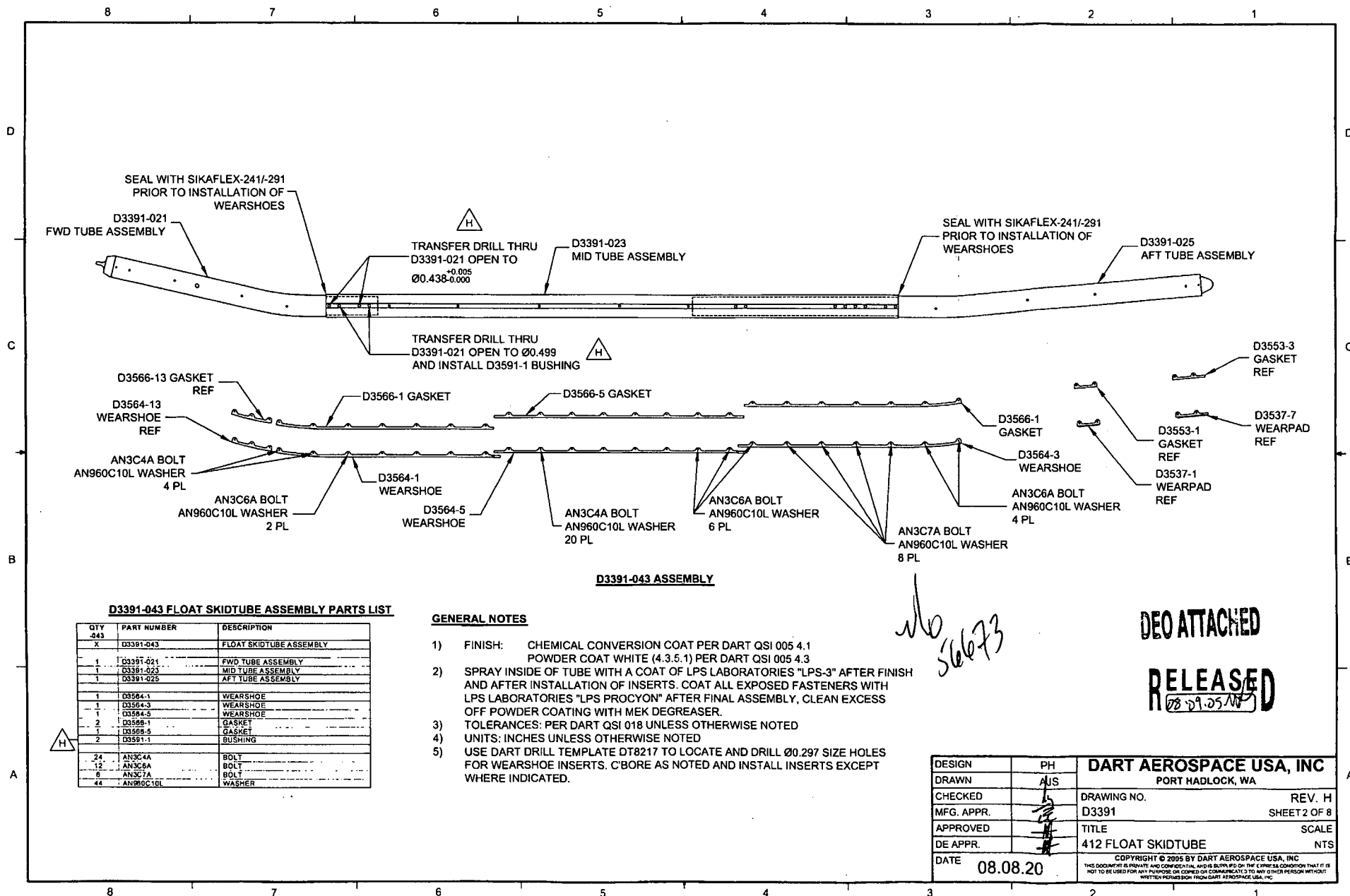
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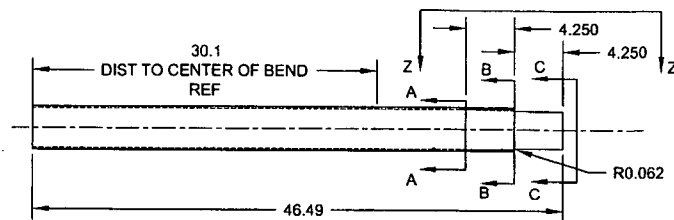
Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

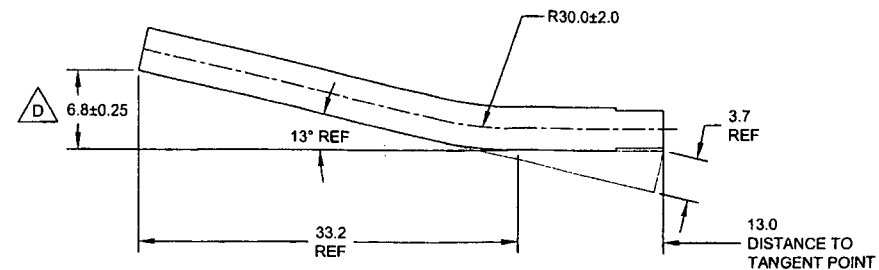
NOTE: Date & initial all entries



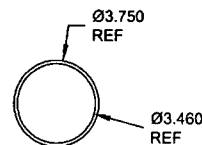




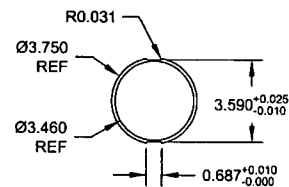
D3391-1 CUTTING DETAIL
(MAKE FROM D6013-047 SKIDTUBE MATERIAL)



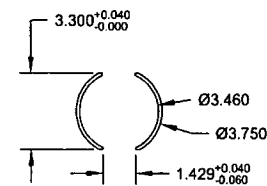
D3391-011/-021 BENDING DETAIL
(MAKE FROM D3391-1)



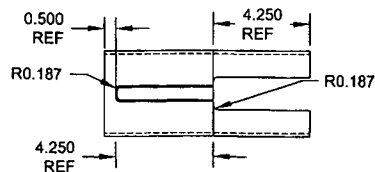
SECTION A-A
SCALE 2X



SECTION B-B
SCALE 2X



SECTION C-C
SCALE 2X

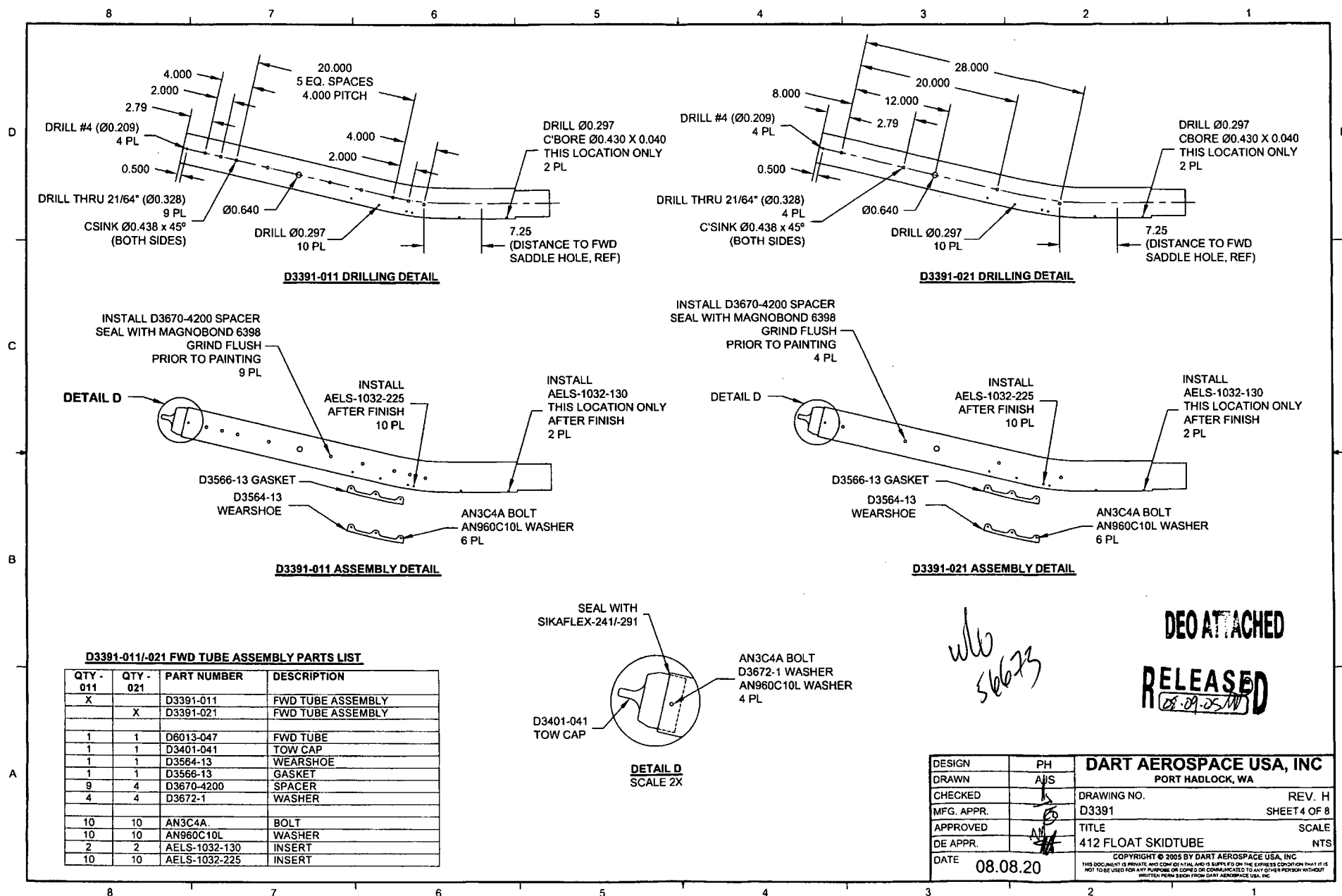


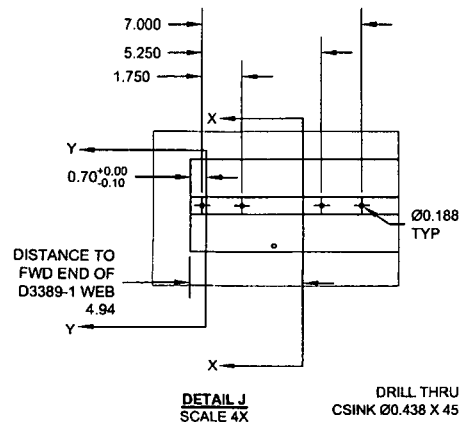
VIEW Z-Z
SCALE 2X

*also
sketch*

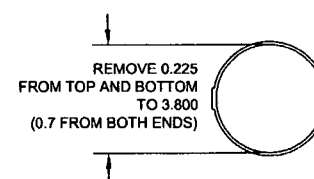
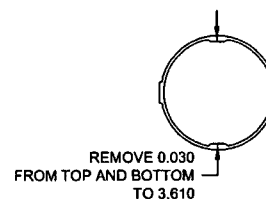
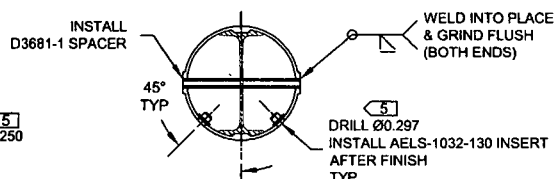
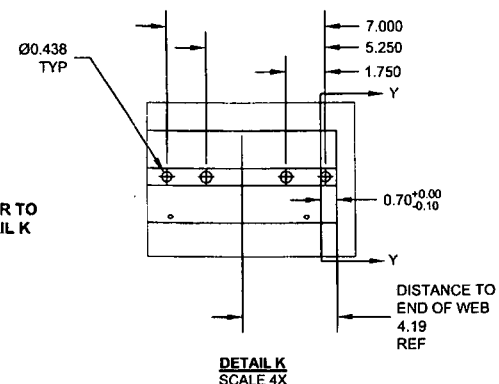
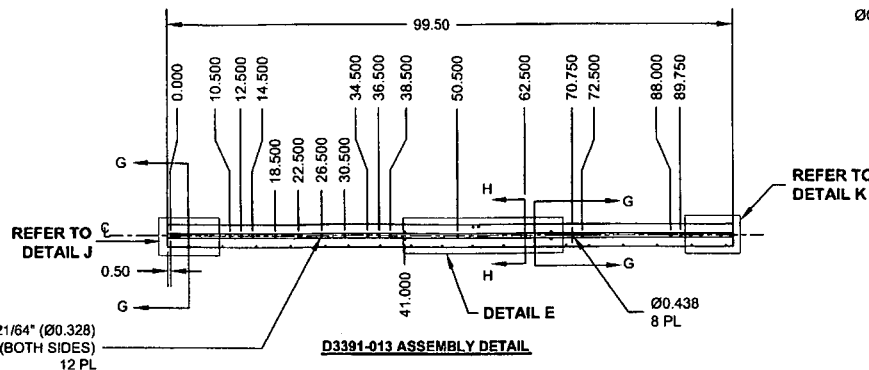
DEO ATTACHED
RELEASED
20-05-11

DESIGN	PH	DART AEROSPACE USA, INC	
DRAWN	AUS	PORT HADLOCK, WA	
CHECKED		DRAWING NO. D3391	REV. H
MFG. APPR.		TITLE	SHEET 3 OF 8
APPROVED		412 FLOAT SKIDTUBE	SCALE
DE APPR.			NTS
DATE	08.08.20	<small>COPYRIGHT © 2005 BY DART AEROSPACE USA, INC THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE USA, INC.</small>	



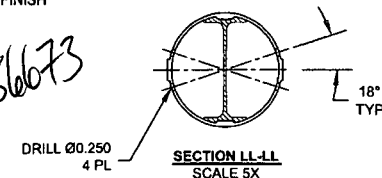
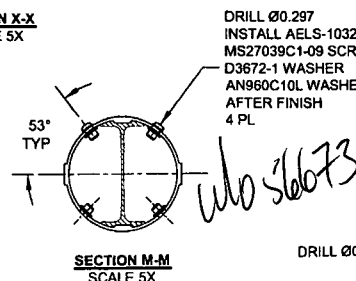
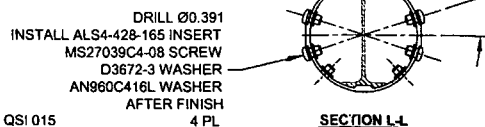
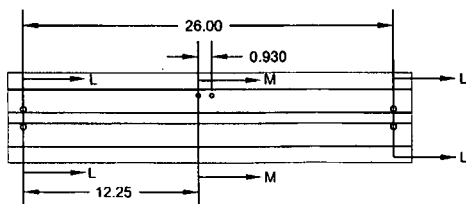


DRILL THRU 21/64" (Ø0.328)
CSINK Ø0.438 X 45° (BOTH SIDES)
12 PL



D3391-013 MID TUBE ASSEMBLY PARTS LIST

QTY -013	PART NUMBER	DESCRIPTION
X	D3391-013	MID TUBE ASSEMBLY
1	D2500-1-100	EXTRUSION
1	D3389-1	WEB
4	D3672-1	WASHER
4	D3672-3	WASHER
12	D3681-1	SPACER
24	ALS-1032-130	INSERT
4	ALS4-428-165	INSERT
4	AN960C10L	WASHER
4	AN960C416L	WASHER
4	MS27039C1-09	SCREW
4	MS27039C4-08	SCREW



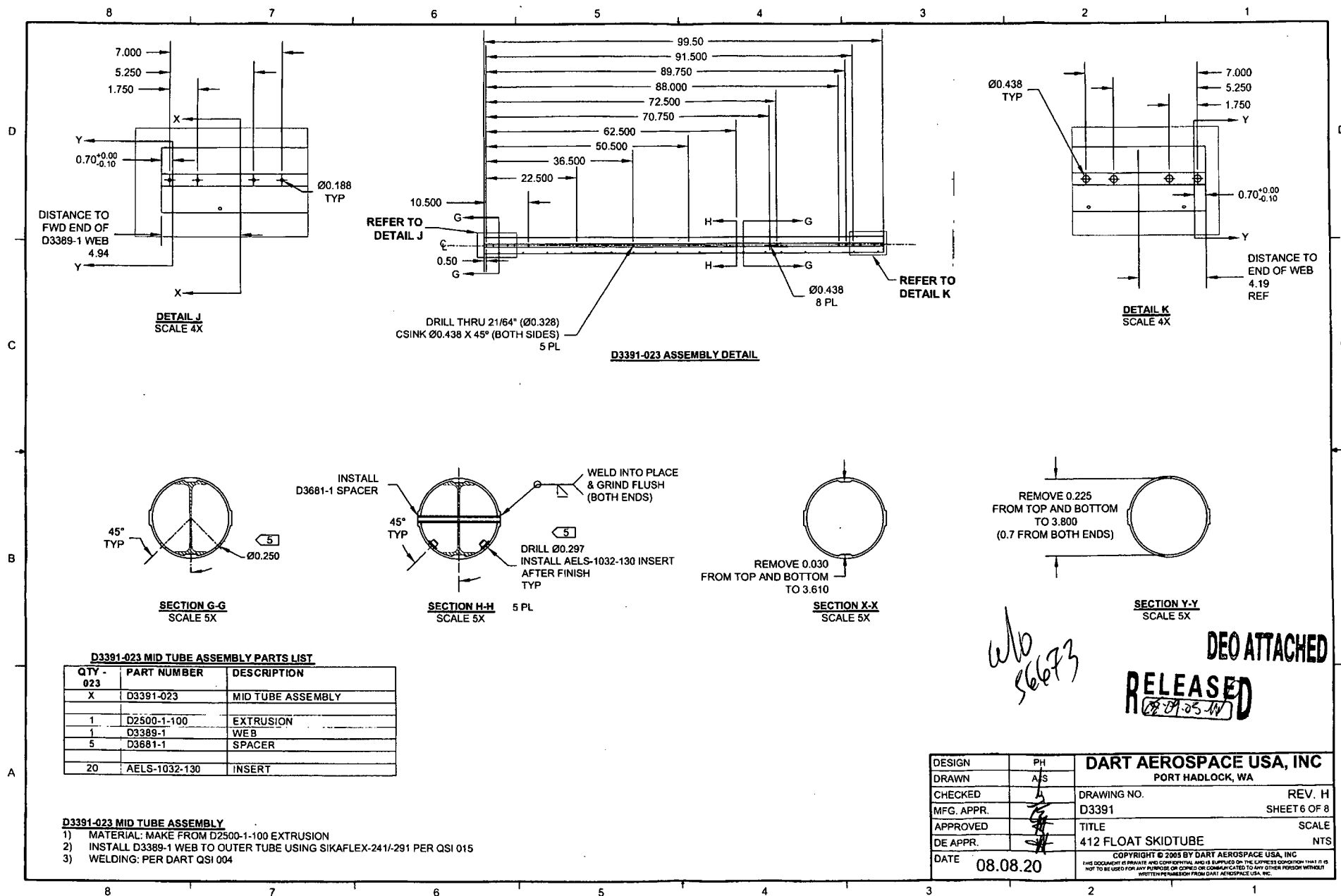
DEO ATTACHED

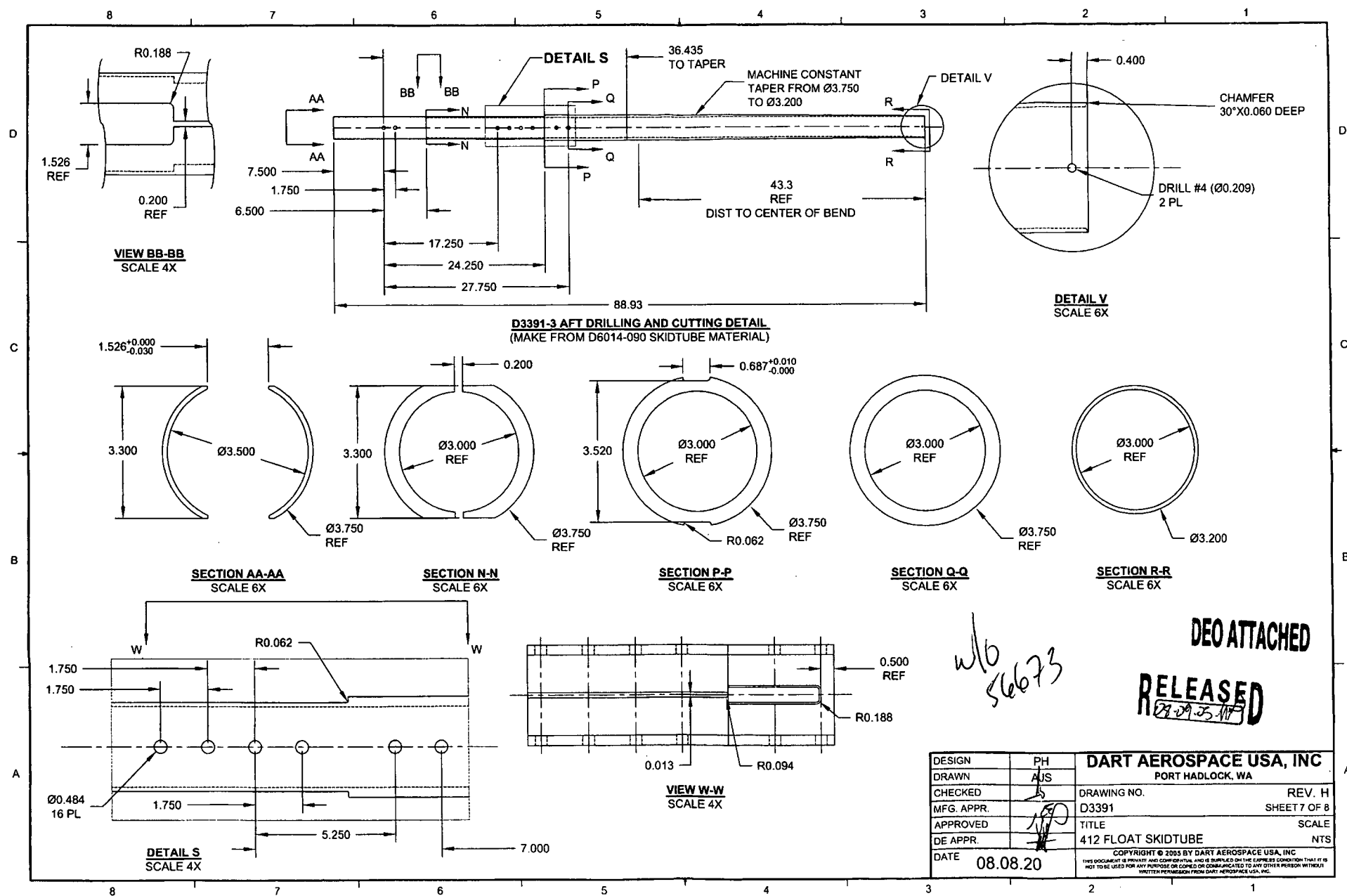
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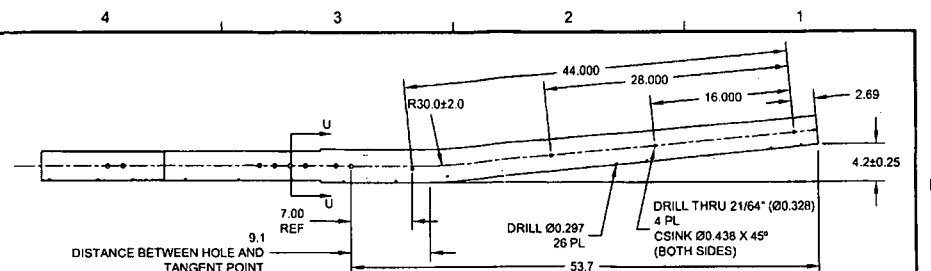
D3391-013 MID TUBE ASSEMBLY

- 1) MATERIAL: MAKE FROM D2500-1-100 EXTRUSION
- 2) INSTALL D3389-1 WEB TO OUTER TUBE USING SIKAFLEX-241/-291 PER QSI 015
- 3) WELDING: PER DART QSI 004

DESIGN	PH	DART AEROSPACE USA, INC	
DRAWN	AJS	PORT HADLOCK, WA	
CHECKED		DRAWING NO. D3391	REV. H
MFG. APPR.			SHEET 5 OF 8
APPROVED		TITLE	SCALE
DE APPR.		412 FLOAT SKIDTUBE	NTS
DATE	08.08.20	COPYRIGHT © 2005 BY DART AEROSPACE USA, INC THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS ORDER THAT IT IS NOT TO BE USED FOR ANY PURPOSES OR COPIED OR COMMUNICATED TO ANY OTHER PERSON OR ENTITY WITHOUT PERMISSION FROM DART AEROSPACE USA, INC	

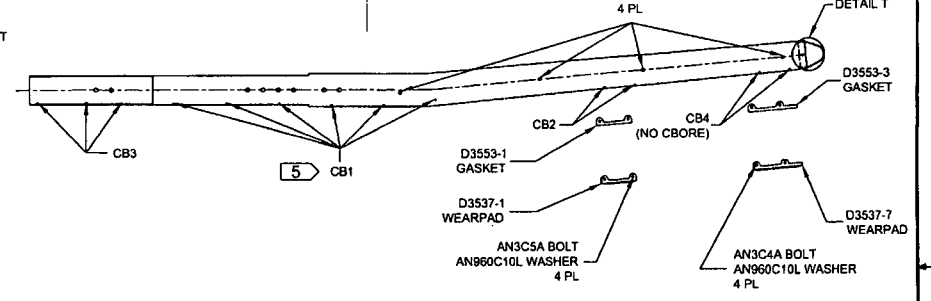






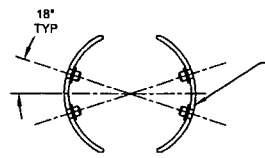
D3391-025 BENDING AND DRILLING DETAIL
(SEE CBORE DETAIL BELOW)

INSTALL D3670-4200 SPACER
SEAL WITH MAGNOBOND 6398
GRIND FLUSH
PRIOR TO PAINTING
4 PL

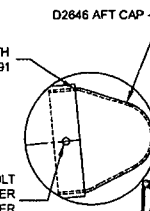


D3391-025 ASSEMBLY AND CBORE DETAIL
(SEE TABLE)

QTY - 015	QTY - 025	PART NUMBER	DESCRIPTION
X	X	D3391-015	AFT TUBE ASSEMBLY
		D3391-025	AFT TUBE ASSEMBLY
1	1	D6014-090	AFT TUBE
1	1	D2846	AFT CAP
1	1	D3537-1	WEARPAD
1	1	D3537-7	WEARPAD
1	1	D3553-1	GASKET
1	1	D3553-3	GASKET
14	4	D3670-4200	SPACER
2	2	D3672-1	WASHER
14	14	AELS-1032-130	INSERT
12	12	AELS-1032-225	INSERT
4		AL 54-428-165	INSERT
6	6	AN3C4A	BOLT
4	4	AN3C5A	BOLT
10	10	AN950C-10L	WASHER



SECTION CC-CC
SCALE 3X

SEAL WITH
SIKAFLEX-241/-291

DETAIL T
SCALE 4X

AN3C4A BOLT
D3672-1 WASHER
AN960C10L WASHER
2 PL

DEO ATTACHE

RELEASED
08-09-05

HOLES MARKED	QTY D3391-015	QTY D3391-025	CBORE	PIN
CB1	12	12	Ø0.430 X 0.170	AELS-1032-225
CB2	4	4	Ø0.430 X 0.170	AELS-1032-130
CB3	6	6	Ø0.430 X 0.040	AELS-1032-130
CB4	4	4	NONE	AELS-1032-130

HOLES MARKED	QTY D3391-015	QTY D3391-025	CBORE	PIN
CB1	12	12	Ø0.430 X 0.170	AELS-1032-225
CB2	4	4	Ø0.430 X 0.170	AELS-1032-130
CB3	6	6	Ø0.430 X 0.040	AELS-1032-130
CB4	4	4	NONE	AELS-1032-130

DESIGN	PH	DART AEROSPACE USA, INC	
DRAWN	AS	PORT HADLOCK, WA	
CHECKED	JS	DRAWING NO.	REV. H
MFG. APPR.	ES	D3391	SHEET 8 OF 8
APPROVED	JS	TITLE	SCALE
DE APPR.	JS	412 FLOAT SKIDTUBE	NT
DATE 08.08.20		COPYRIGHT © 2005 BY DART AEROSPACE USA, INC THIS DOCUMENT IS THE PROPERTY OF DART AEROSPACE USA, INC. IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT THE WRITTEN PERMISSION OF DART AEROSPACE USA, INC.	

DRAWING NO. D3391	TITLE 412 FLOAT SKIDTUBE	REV. H	DART AEROSPACE USA, INC ENGINEERING ORDER		D.E.O. NO. D3391-H-1	SHEET NO. SHEET 1 OF 1	SCALE NTS
DRAWN <i>CP</i>	CHECKED <i>h</i>	MFG. APPR. <i>AA</i>	APPROVED <i>MP</i>		DE APPR. <i>h</i>		
DATE 09.09.23	DATE 06.09.24	DATE 09/09/25	DATE 09/09/30		DATE 09/09/30		

PURPOSE:

LPS-3 IS NO LONGER USED DURING ASSEMBLY OF D3391-041/-043 SKIDTUBES.

CHANGE:

AMEND NOTE 2 OF D3391-041/-043 SKIDTUBE ASSEMBLIES (ZN A6-1, A6-2) AS FOLLOWS:

- 2) ~~SPRAY INSIDE OF TUBE WITH A COAT OF LPS LABORATORIES "LPS-3" AFTER FINISH~~
~~AND AFTER INSTALLATION OF INSERTS. COAT ALL EXPOSED FASTENERS WITH~~
 LPS LABORATORIES "LPS PROCYON" AFTER FINAL ASSEMBLY, CLEAN EXCESS
 OFF POWDER COATING WITH MEK DEGREASER.

RELEASED
 2010-02-02
MP

*who
 sleb 73*

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